



Dart Aerospace Ltd.
1270 Aberdeen St
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D4776-1

Job Sheet 180571



Part No: D4776-1

Job Qty: 25 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/15/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	13 Ea	7/15/18	7/15/18	0.00	0.00	Start Up Machining-3		18/07/13
100	Doosan	13 pcs	7/15/18	7/15/18	0.54	6.91	Doosan		18/07/13
105	QC	13 pcs	7/15/18	7/15/18	0.00	0.00	QC2 Machining-3		18/07/13
111	QC	13 pcs	7/15/18	7/15/18	0.00	0.00	QC8 Machining-3		18/07/13
112	HandFinish	13 pcs	7/15/18	7/15/18	0.00	0.37	HandFinish1		18-07-15
113	QC	13 pcs	7/15/18	7/15/18	0.00	0.00	QC7-4		18-07-17
115	Powdercoat	13 pcs	7/15/18	7/15/18	0.00	0.15	Powdercoat1		18-07-18
116	QC	13 pcs	7/15/18	7/15/18	0.00	0.00	QC3		18-07-18
130	Packaging	13 pcs	7/15/18	7/15/18	0.00	0.00	Packaging3-2		18-07-18
140	QC21-SA	13 Ea	7/15/18	7/15/18	0.00	0.00	QC21		18-07-18

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M B8834. START: 7:45 OUT: 3:00 FINISH: 8:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	3.7700 ft (.29 ea)	90-Start up Operation	5068913

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	4	48	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis <i>0.880</i>	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis <i>0.440</i>	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis <i>0.375</i>	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis <i>0.625</i>	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis <i>1.750</i>	1.750Inches ± 0.030	1.780 1.720		
6	Basket Strut Clevis <i>3.500</i>	3.500Inches ± 0.030	3.530 3.470		
7	Basket Strut Clevis <i>45°</i>	45.000Degrees ± 0.500	45.500 44.500	Angle	
8	Basket Strut Clevis <i>0.030</i>	0.030Inches ± 0.030	0.060 0.000		
9	Basket Strut Clevis <i>0.060</i>	0.060Inches ± 0.030	0.090 0.030	Radius	
10	Basket Strut Clevis <i>0.198</i>	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	
11	Basket Strut Clevis <i>0.263</i>	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	
12	Basket Strut Clevis <i>0.41</i>	0.410Inches ± 0.030	0.440 0.380	Radius	
13	Basket Strut Clevis <i>1.130</i>	1.130Inches ± 0.030	1.160 1.100		
14	Basket Strut Clevis <i>0.188</i>	0.188Inches ± 0.010	0.198 0.178		
15	Basket Strut Clevis <i>0.190</i>	0.190Inches ± 0.030	0.220 0.160		
16	Basket Strut Clevis <i>0.500</i>	0.500Inches ± 0.030	0.530 0.470		
17	Basket Strut Clevis <i>0.750</i>	0.750Inches ± 0.010	0.760 0.740		
18	Basket Strut Clevis <i>0.399</i>	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	
19	Basket Strut Clevis <i>0.130</i>	0.130Inches ± 0.030	0.160 0.100	Radius	
20	Basket Strut Clevis <i>0.755</i>	0.750Inches + 0.010 - 0.000	0.760 0.750		
21	Basket Strut Clevis <i>0.160</i>	0.160Inches ± 0.030	0.190 0.130		
22	Basket Strut Clevis <i>45°</i>	45.000Degrees ± 0.500	45.500 44.500	Angle	

Plex 7/10/18 10:36 AM dart.leroux.jason



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Container No: S091738



Part: D4776-1

Job No: 180571

Serial No/Batch: S091738

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/13/18